

Work Order ID 50747

July 21, 2009 12:43:57 PM



Page 1

Item ID: D2017-129

Accept



Setup Start



Revision ID: E

Stop



Item Name: Step Strut

Start Date: 7/06/09 Start Qty: 2.00



Cust Item ID:

Required Date: 7/06/09 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: *✓*

Date: Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description
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Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D2017	Rev F
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100	QC5- Inspect part completeness to step on W/O
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0.00

2/20/09/10

QC	Memo
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0.00

Quality Control

90	Pouch tube as per Dwg + Deburr
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0.00

8B 09/09/09
m-h 09/09/10

110	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel
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0.00

Powdercoat	Memo
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0.00

Powder Coating	START TIME: 11:15AM FINISH TIME: 11:45AM
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MOVEN TEMPERATURE: 400°F

2/1 09-09-14

120	QC3- Inspect Part Finish
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0.00

QC	Memo
----	------

0.00

Quality Control	<i>BL 09/09/14</i>
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Required Date: 7/06/09 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Packaging

Packaging

Identify as per dwg & Stock Location: 150

0.00

9/9/11 2x SP

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

09/09/11 HJ
09/09/11

Status	Item ID	Rev	Name	Start Date	Quantity	Per Job	Op Date	Scrap %	Quality	Ind N/C	I/CX	Sortme	Offset	Qty	Per Och	To Vore	Ce Last	Ind Da	
<input checked="" type="checkbox"/>	M304TR0.750W.049		304 RD Tube .750...	6/24/09	2.6417	f		100	51	0.0...					1	0	M...	6/3...	6/...

Picklist Print

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July 22, 2009 12:18:49 PM

Work Order ID: 50747



Parent Item: D2017-129RevE



Parent Item Name: Step Strut

Start Date: 7/06/09

Required Date: 7/06/09

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304TR0.750W.049		Purchased		No			f	350.2300	5.2834			

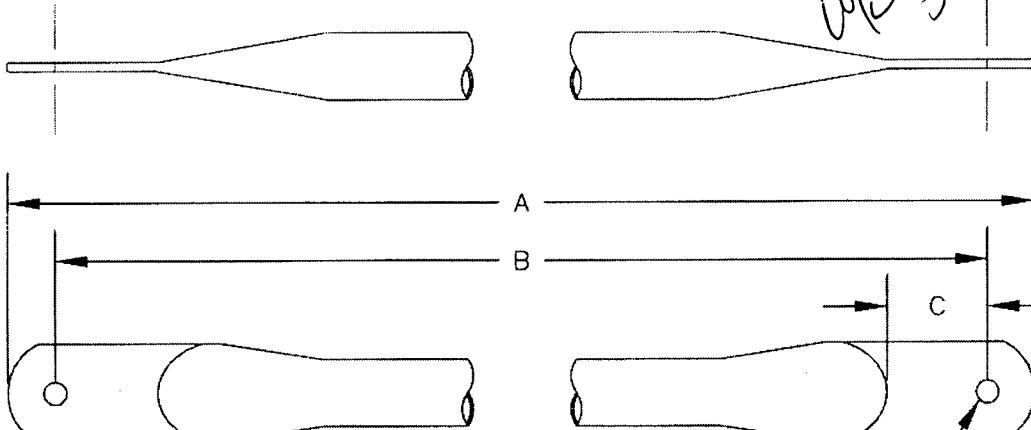
304 RD Tube .750 x .049W



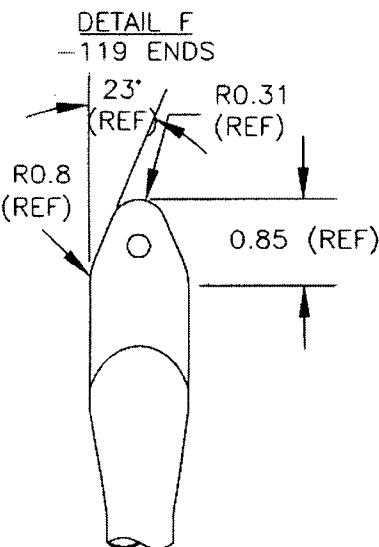
<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
Main Warehouse		
MAT	350.2300026	
107518	7.27	
108498	0	
109314	8.5	
110113	0.73	
110271	0.03	
111096	9	
111457	11.43	
111619	13.2700026	
112187	300	

6 88-0910969

PUNCH ENDS PER
SPEC CTRL D2638
(-119 SEE NOTE)



"D" DIA 0.25 TO BE PUNCHED (TYP. BOTH ENDS)
"E" DIA TO BE OPENED MANUALLY (ONE END ONLY)



Part Number	A	B	C	D	E
D2017-101	17.73	16.93	1.30	0.250	0.312
D2017-103	18.74	17.94	1.30	0.250	0.312
D2017-105	14.95	14.15	1.30	0.250	-
D2017-107	15.61	14.81	1.30	0.250	-
D2017-109	13.93	13.13	1.30	0.250	-
D2017-111	15.30	14.50	1.30	0.250	-
D2017-113	20.50	19.70	1.30	0.250	0.312
D2017-115	12.42	11.62	1.30	0.250	-
D2017-117	13.86	13.06	1.30	0.250	-
D2017-119	26.75	25.95	1.30	0.250	-
D2017-121	12.30	11.50	1.30	0.250	-
D2017-123	12.92	12.12	1.30	0.250	-
D2017-125	19.55	18.75	1.30	0.250	-
D2017-127	20.30	19.50	1.30	0.250	-
D2017-129	31.43	30.63	1.30	0.250	-
D2017-131	19.68	18.88	1.30	0.250	-
D2017-133	30.66	29.86	1.13	0.250	-

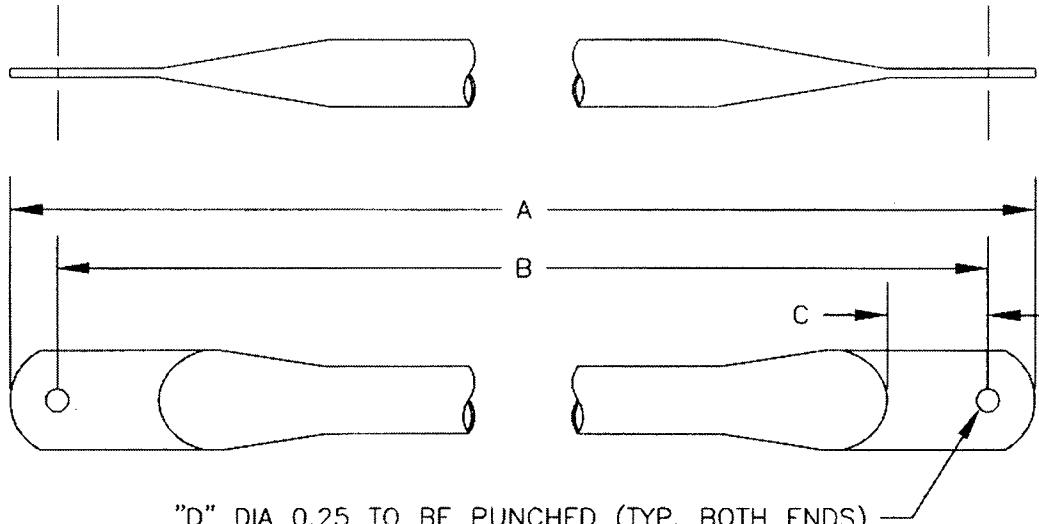
NOTE:

FOR D2017-119: PUNCH PER D2638, GRIND ENDS PER DT8360 (SEE DETAIL F FOR REF.)
BEND FLARED ENDS 8° UP / 8° DOWN

MATERIAL: 304/316/318 SS, 0.75 OD x 0.049 WALL, ENSURE SEAMLESS TUBING IS USED
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

304/316/318 SS
DART
DA COPY DATE

DESIGN BN	DRAWN BY	DART AEROSPACE LTD		
CHECKED	APPROVED	DRAWING NO. D2017		
DATE	99.04.16	TITLE STEP STRUTS		
C	95.01.26	STEP STRUTS		
D	96.03.28	ADDED PARTS		
E	99.04.16	ENDS PUNCHED PER SPEC CTRL -119 CHANGE (TSR A897)		
		F1 1/16 INCH = 1.6MM		
		REV. E SHEET 1 OF 2		
		SCALE NTS		



"D" DIA 0.25 TO BE PUNCHED (TYP. BOTH ENDS)

Part Number	A	B	C	D
D2017-201	21.31	20.51	1.30	0.250
D2017-203	16.39	15.59	1.30	0.250
D2017-205	16.53	15.73	1.30	0.250
D2017-207	13.85	13.05	1.30	0.250
D2017-209	15.64	15.33	1.30	0.250
D2017-211	15.67	14.87	1.30	0.250
D2017-213	15.82	15.02	1.30	0.250
D2017-215	16.47	15.67	1.30	0.250
D2017-217	16.70	15.90	1.30	0.250
D2017-219	13.65	12.85	1.30	0.250
D2017-221	13.58	12.78	1.30	0.250
D2017-223	12.95	12.15	1.30	0.250
D2017-225	13.99	13.19	1.30	0.250
D2017-227	30.67	29.87	1.30	0.250

50747

NOTE:-

**MATERIAL: 304/316/318 SS, 0.75 OD x 0.049 WALL, ENSURE SEAMLESS TUBING IS USED
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED**

FIG. 11. RUMBLE GAT WIRE (435-2) FOR 1000 ft. x 100 ft.



DESIGN	DRAWN BY		
BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED	APPROVED	DRAWING NO.	REV. E
<i>[Signature]</i>	<i>[Signature]</i>	D2017	SHEET 2 OF 2
DATE	TITLE		
99.04.16	STEP STRUTS		
	SCALE		
	NTS		